Work Order ID 66757

Friday, February 25, 2011 1:19:39 PM

Item ID: D350-636-011 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Skidtube LH

Start Date: 2/25/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 3/11/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** ll **Date:** 1-02-25 **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC		0.00							
Document Control									

Draw Nbr	Revision Nbr
IIN-D350-636	H

Memo

Photocopy blue file and type labels per PPP-D350-636-011 CHG 006

ll 04 14 ①

B66757

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes	0.00							
Skidtubes									

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***

8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

B 11/03/18

Dart Aerospace Ltd

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Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M116577 BE 1/03/18								
	12-Grind welds flush as per Dwg D2750 BE 1/03/18								
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
130 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							

Dart Aerospace Ltd

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Cust Item ID:
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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish						1			JB 11/03/22
Hand Finishing	Memo	0.00							
150	QC3- Inspect Part Finish	0.00							
QC									11-3-22
Quality Control	Memo	0.00							

Dart Aerospace Ltd

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
Skidtubes	Skidtubes								
Skidtubes		0.00							

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015
A/R □□□ Sikaflex-291 batch: M1160410 □□□
exp. date: 09/2011

BE 11/03/25

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)
A/R□□□ Aluminum Rod batch: M116577 BE 11/03/31

9- At section AJ-AJ drill out x-bolt spacer to 0.404" BE 11/04/01

10-Grind welds flush as per Dwg D2750 BE 11/04/01

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								
	12-Deburr holes								
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
180 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	ϕ	SI	11/04/04
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 115951	0.00				1		BL	11-4-4
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:40 OVEN TEMPERATURE: 320° FINISH TIME: 9:10								
210	QC3- Inspect Part Finish	0.00				1	ϕ	SI	11/04/05
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00				1	ϕ		11/04/06
HandFinish	**Memo**	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
230	HandFinishing	0.00				1	ϕ		11/04/06
HandFinish	**Memo**	0.00							
Hand Finishing	1-Inspect for Foreign Objects								

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: M 116 918
EXP DATE: _____

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M 114189

5-Coat all exposed fasteners with "LPS Procyon" batch: M 114596

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control	******ensure antiseize is on AN8C21A bolts*******								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
Packaging	Packaging								
Packaging	**Memo**	0.00 Rev E L-72					11/4/14		
Packaging	Package as per PPP D350-636-011								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00					11/4/15		
Quality Control									

MF
11-04-14

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Friday, February 25, 2011 1:19:46 PM

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Work Order ID: 66757

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:I□02.09.25□Rearranged procedure steps□KJ□
IPP Rev:J 06-03-23 As per Rev D JLM
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
DD verified by:EC IPP Rev:P 10.06.22
revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN
revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3 O-Ring, 205 Skidtube		Manufactured	No			230	Each	1,031.000	8	8			
AN960JD816 1/2" washer,Alum		Purchased	No			250	Each	89.0000	2	2			

11/04/05

Location		Loc Qty	Loc Code
FP		543	
	55546	19	
	58191	12	
	59358	12	
	65518	500	x8
fpa		488	
	61762	488	

11/4/14

Location		Loc Qty	Loc Code
ST348		89	
	106043	89	

2

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2744	Manufactured	No	110	Each	55.0000	1	1	AE 11/03/18
Cap								

Location	Loc Qty	Loc Code
LG	29	
65086	29	
ST	26	
62715	26	

D2600-3-BENT	Manufactured	No	110	Each	6.0000	1	1	11/03/18
Extrusion Bent								

Location	Loc Qty	Loc Code
LG 66875	6	
61634	2	
62764	1	
64434	3	

D2743	Manufactured	No	160	Each	122.0000	8	8	AE 11/03/31
Crossbolt Spacer								

Location	Loc Qty	Loc Code
LG	122	
50281	10	
57953	2	
59111	10	
61844	16	
64003	84	

8

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Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2739	Manufactured	No	160	Each	4.0000	1	1	BE 11/03/25
350 I Beam								B 66981 x1

Location	Loc Qty	Loc Code
LG	4	
64448	4	

D3490-3	Manufactured	No	160	Each	35.0000	4	4	BE 11/03/31
Cross Bolt Spacer								

Location	Loc Qty	Loc Code
LG	35	
60294	1	
63556	24	
64006	10	

4

D3490-1	Manufactured	No	160	Each	61.0000	4	4	BE 11/03/31
Cross Bolt Spacer								

Location	Loc Qty	Loc Code
LG	61	
59424	3	
62450	48	
64005	10	

4

ALS4-1032-225	Purchased	No	220	Each	3,945.000	38	38	Jl 11/04/05
Insert								

Location	Loc Qty	Loc Code
PK011	3945	
110768	3945	

X38

Dart Aerospace Ltd

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Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3492-041	Manufactured	No	230	Each	93.0000	8	8	
Plug Assembly								

Location	Loc Qty	Loc Code
FP013	93	
59114	1	
62210	3	B66937
63994	29	
65068	60	

D3793-3	Manufactured	No	230	Each	20.0000	1	1	
Wearshoe								

Location	Loc Qty	Loc Code
FP018	15	
39479	1	
39812	2	
64447	12	
FP18	4	
61711	4	
FP19	1	
57947	1	

AN8C35A	Purchased	No	230	Each	61.0000	1	1	
BOLT								

Location	Loc Qty	Loc Code
ST345	25	
116874	25	
ST346	36	
114442	5	
115188	5	
115960	26	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Friday, February 25, 2011 1:19:46 PM

Work Order ID: 66757

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3793-1	Manufactured	No	230	Each	25.0000	1	1	gl 11/04/05
Wearshoe								

Location	Loc Qty	Loc Code	
FP018	17		
39277	1		
39715	2		
64445	14		
FP18	8		
59151	1		
59630	1		
61710	6		X1

D3488-041	Manufactured	No	230	Each	17.0000	1	1	gl 11/04/05
Blade Fitting Assembly, LH								

Location	Loc Qty	Loc Code	
FG008	10		
62002	10		X1
FP18	7		
61689	7		

D3794-3	Manufactured	No	230	Each	19.0000	1	1	gl 11/04/05
Gasket								

Location	Loc Qty	Loc Code	
FP010	3		
39422	3		
FP10	15		
60826	1		
61712	14		X1
FP18	1		
59153	1		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Friday, February 25, 2011 1:19:47 PM

Work Order ID: 66757

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN6C44A	Purchased	No	230	Each	97.0000	4	4	
BOLT								Yl 11/04/05

Location		Loc Qty	Loc Code	
FG		2		
	103964	2		
ST344		95		
	111649	2		
	114653	1		
	115936	42		
	116874	50		xl

MS21083C8	Purchased	No	230	Each	43.0000	1	1	
NUT								Yl 11/04/05

Location		Loc Qty	Loc Code	
ST303		43		
	113845	5		
	114934	3		
	115594	4		
	115884	31		x1

D3536-25	Manufactured	No	230	Each	24.0000	1	1	
Gasket								Yl 11/04/05

Location		Loc Qty	Loc Code	
FP		12		
	65903	12		
FP12		9		
	64446	9		x1
FP-12		3		
	39234	3		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Friday, February 25, 2011 1:19:47 PM

Work Order ID: 66757

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3631-1		Manufactured	No	230	Each	144.0000	8	8	
Washer									Jl 11/04/05
	Location			**Loc Qty**		**Loc Code**			
	ST072			144		B66959			X8
		63647		144					
D3791-1		Manufactured	No	230	Each	14.0000	1	1	
Wearplate									Jl 11/04/05
	Location			**Loc Qty**		**Loc Code**			
	FP017			3					
		39276		1					
		39418		2					
	FP17			11					
		62239		11					X1
AN960C10L	NAS1149C0332R	Purchased	No	230	Each	127.0000	38	38	
washer									Jl 11/04/05
	Location			**Loc Qty**		**Loc Code**			
	ST245			127		M117291			X38
		107534		59					
		108246		68					
D2745		Manufactured	No	230	Each	121.0000	8	8	
Bushing									Jl 11/04/05
	Location			**Loc Qty**		**Loc Code**			
	ST023			121					
		52311		5					
		59112		4					
		61988		4					
		63315		108					X8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:19:47 PM

Work Order ID: 66757

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN3C5A	Purchased	No	230	Each	1,024.000	34	34	
Bolt								

Location	Loc Qty	Loc Code	
ST350	1024		
107862	68		
108302	34		
114330	11		
115015	13		
115371	4		
115422	100		
115835	194		
116419	500		X34
116549	100		

D3537-1	Manufactured	No	230	Each	33.0000	3	3	
Wearpad								

Location	Loc Qty	Loc Code	
FP017	33		
37749	6		
65057	27	B65927	X3

AN960C816L *	Purchased	No	230	Each	0.0000	1	1	

WASHER NAS1149C08332R / M114915

(x1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:19:48 PM

Work Order ID: 66757

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3492-043 Plug Assembly	Manufactured	No	230	Each	41.0000	8	8 lel 11/04/05

Location	Loc Qty	Loc Code	
FP	2		
54682	2		
FP013	39	1366931	X8
59117	1		
59190	4		
63996	2		
65070	32		

AN3C6A BOLT	Purchased	No	230	Each	359.0000	4	4 lel 11/04/05

Location	Loc Qty	Loc Code	
ST351	359		
111982	134		X4
116419	75		
116549	50		
116704	100		

NAS1611-013 O-RING	Purchased	No	230	Each	248.0000	8	8 lel 11/04/05

Location	Loc Qty	Loc Code	
FP	248		
115460	100	M117291	X8
115589	28		
115812	20		
116582	100		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Friday, February 25, 2011 1:19:48 PM

Work Order ID: 66757

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3535-25 Wearshoe	Manufactured	No	230	Each	21.0000	1	1	JL 11/04/05

Location	Loc Qty	Loc Code	
FP18	21		
38867	1		
39716	2		
62233	6		
65167	12		X1

D3794-1 Gasket	Manufactured	No	230	Each	15.0000	1	1	JL 11/04/05

Location	Loc Qty	Loc Code	
FP010	15		
39279	1		
39421	2		
61704	12		X1

MS21043-6 NUT	Purchased	No	230	Each	546.0000	4	4	JL 4/04/05

Location	Loc Qty	Loc Code	
ST301	546		
112314	546		X4

D3493-1 Washer	Manufactured	No	250	Each	32.0000	2	2	11/4/14

Location	Loc Qty	Loc Code	
ST062	32		
62677	32		2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, February 25, 2011 1:19:48 PM

Work Order ID: 66757

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS21083C8 NUT	Purchased	No	250	Each	43.0000	2	2	M117291

Location	Loc Qty	Loc Code
ST303	43	
113845	5	
114934	3	
115594	4	
115884	31	

AN8C21A BOLT	Purchased	No	250	Each	71.0000	2	2	11/4/48

Location	Loc Qty	Loc Code
ST345	71	
113558	1	
114653	2	
115723	8	
116381	60	

D3672-1 Phenolic Washer	Manufactured	No	230	Each	1,077.000	8	8	PTO =>

Location	Loc Qty	Loc Code
ST077	1077	
42329	10	
52505	67	
64177	1000	

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W/O: 66757		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/05	230	Assemble with NAS1515H3L / M113362					11 04 15

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Friday, February 25, 2011 1:19:48 PM

Work Order ID: 66757

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 2/25/2011 **Required Date:** 3/11/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2741	Manufactured	No	250	Each	79.0000	1	1	11/4/14
Blade, 350 Skidtube								

Location	Loc Qty	Loc Code
ST466	79	
60210	6	
61341	33	
63589	40	

D3532-1	Manufactured	No	250	Each	31.0000	2	2	11/4/14
Spacer								

Location	Loc Qty	Loc Code
ST065	31	
62218	31	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH:
   ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
    MINIMUM YIELD TENSILE STRENGTH = 35 KSI
    MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL (F)
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE
WORK ORDER
NO. 61757

RELEASED
05 07 22

REV.	DESCRIPTION	BY	DATE
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

DESIGN	PH
DRAWN	PH
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.07.16

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D2750 — REV. F — SHEET 1 OF 11

TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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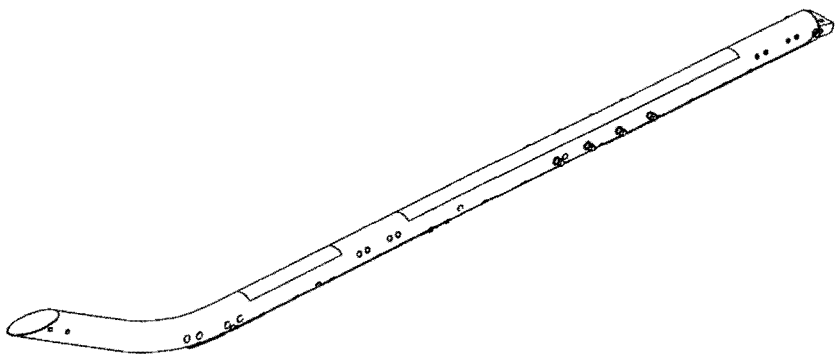
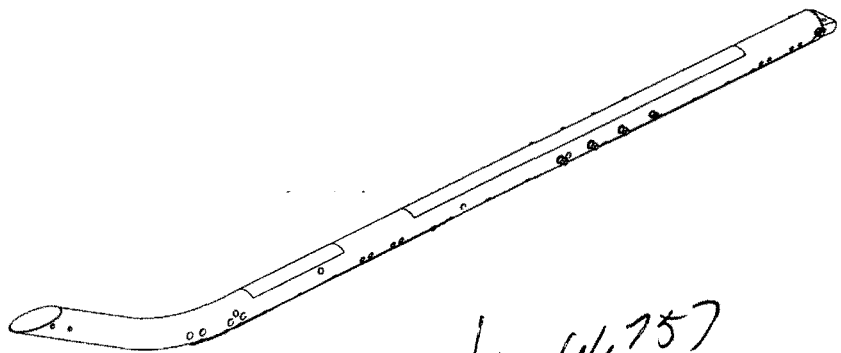


D2750-041 350 SKIDTUBE ASSEMBLY, LH



w/o 66757

D2750-042 350 SKIDTUBE ASSEMBLY, RH

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DESIGN	PGW	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	PGW	
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 2 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE 08.07.16		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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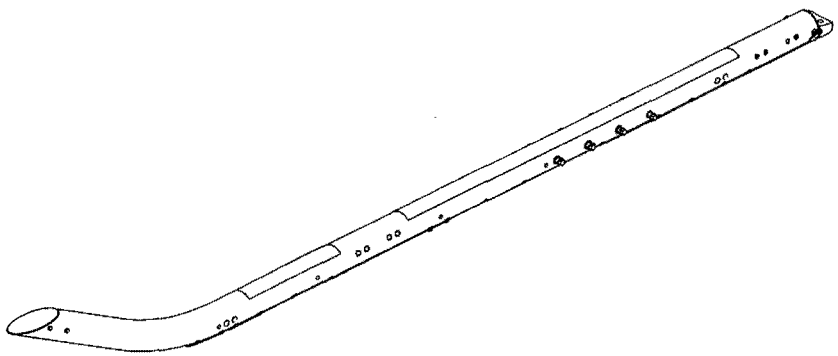
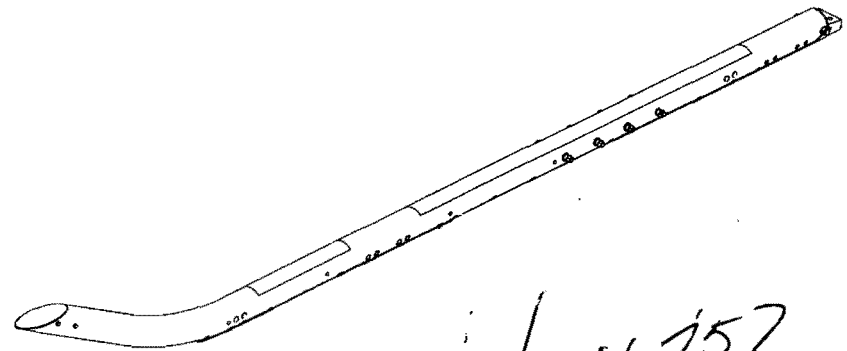


D2750-043 350 SKIDTUBE ASSEMBLY, LH



W/O 66757

D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED 65-9.22

DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	PH	
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 3 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE 08.07.16		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

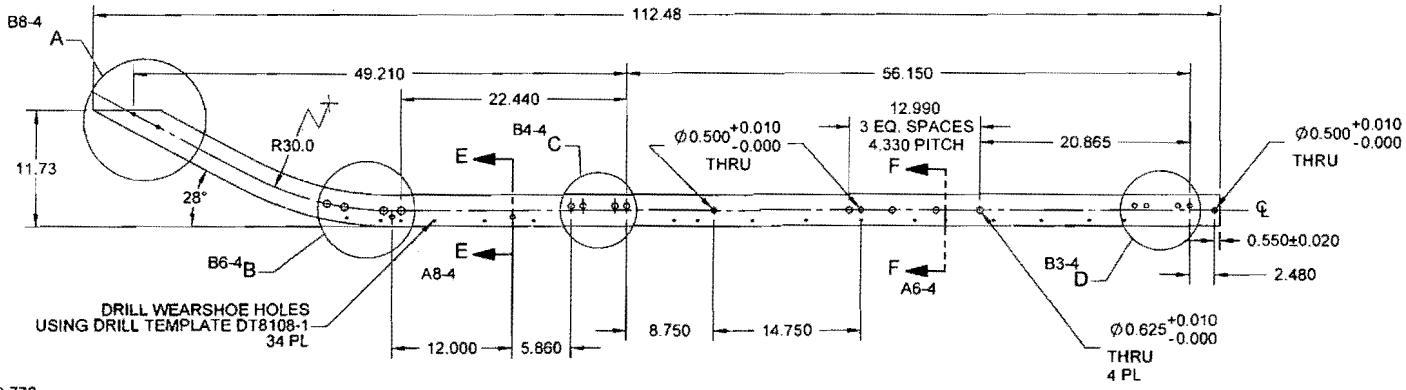
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

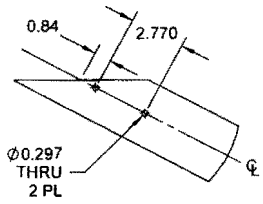
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

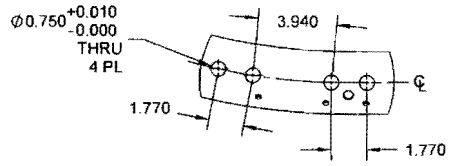
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D2750-1 LH SKIDTUBE



D7-4
DETAIL A
SCALE 2X



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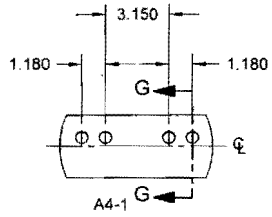
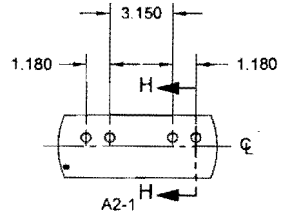
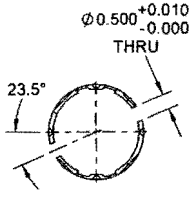


D5-4
DETAIL C
SCALE 2X

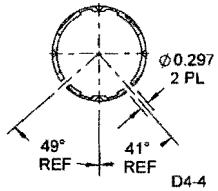


D3-4
DETAIL D
SCALE 2X

u/w 46757



D6-4
SECTION E-E
SCALE 3X, 2 PL



D4-4
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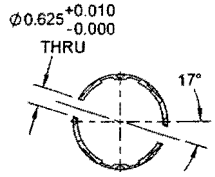
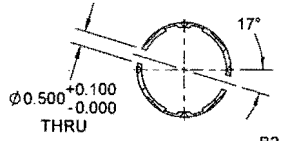
SCALE 3X, 17 PL



B4-4
SECTION G-G
SCALE 3X, 4 PL



B2-4
SECTION H-H
SCALE 3X, 4 PL

RELEASED

DESIGN	PW	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	PW	
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 4 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	08.07.16	

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Dart Aerospace Ltd

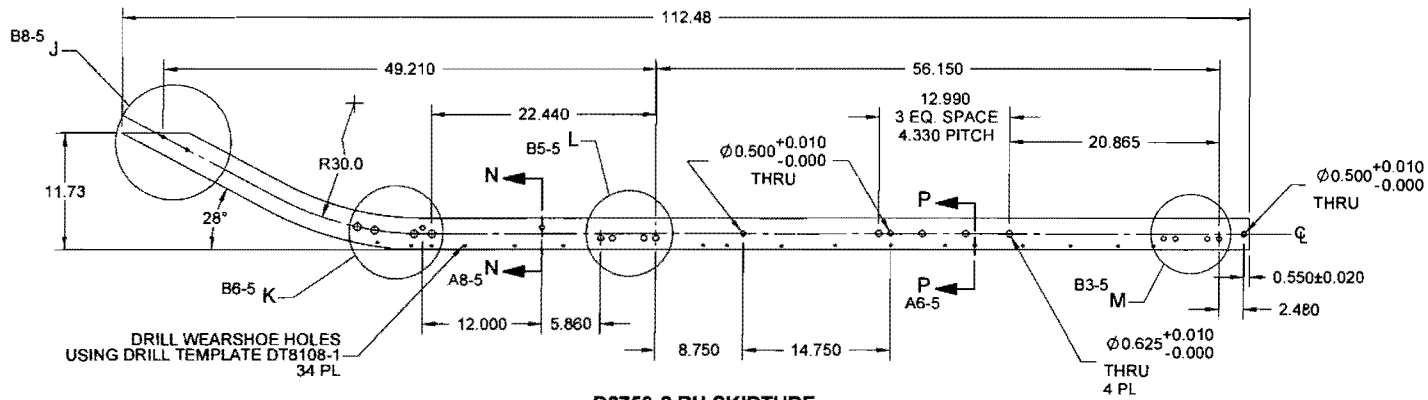
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

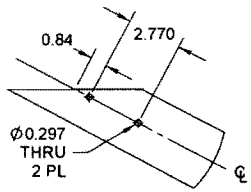
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

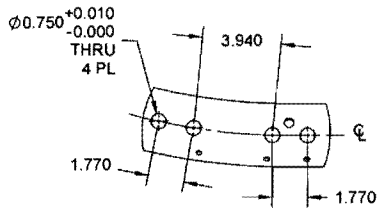


D2750-2 RH SKIDTUBE



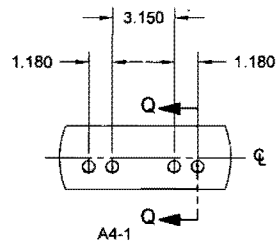
D8-5

DETAIL J
SCALE 2X



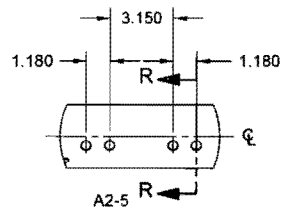
C7-5

DETAIL K
SCALE 2X



D6-5

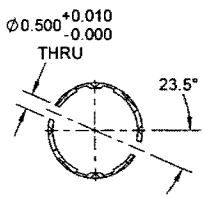
DETAIL L
SCALE 2X



C3-5

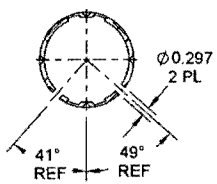
DETAIL M
SCALE 2X

u 166757



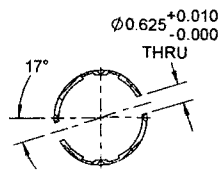
C6-5

SECTION N-N
SCALE 3X, 2 PL



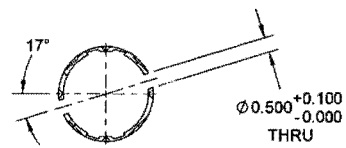
C4-5

SECTION P-P
SCALE 3X, 17 PL



B5-5

SECTION Q-Q
SCALE 3X, 4 PL



B3-5

SECTION R-R
SCALE 3X, 4 PL

RELEASED
8-22-16

DESIGN	PGH	**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN	PGH	
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 5 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	08.07.16	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

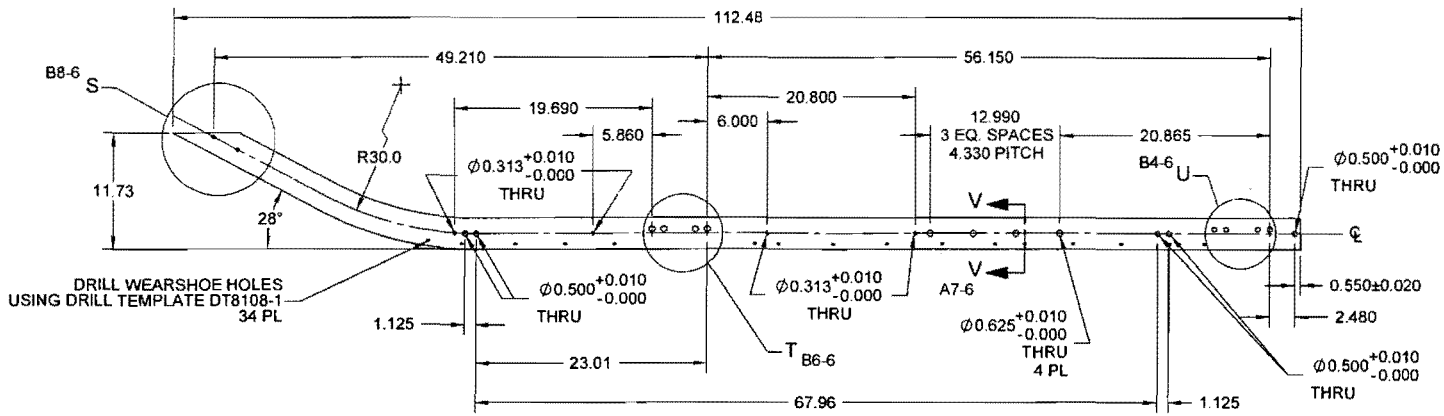
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

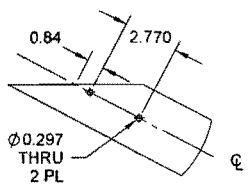
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D2750-3 LH SKIDTUBE



DETAIL S D8-6
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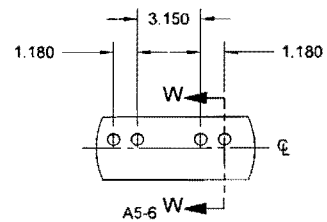

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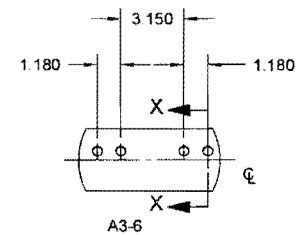
SCALE 2X



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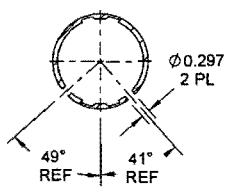
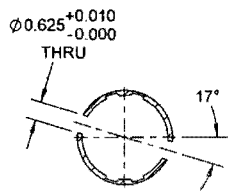
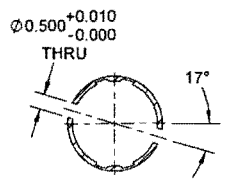
SCALE 2X



SECTION V-V C4-6
SCALE 3X, 17 PL



SECTION W-W B6-6
SCALE 3X, 4 PL



SECTION X-X B4-6
SCALE 3X, 4 PL

w/o 66757

RELEASED
08 JUL 22 '16

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 6 OF 11
MFG. APPR.		
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS
DE APPR.		
DATE 08.07.16		

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Dart Aerospace Ltd

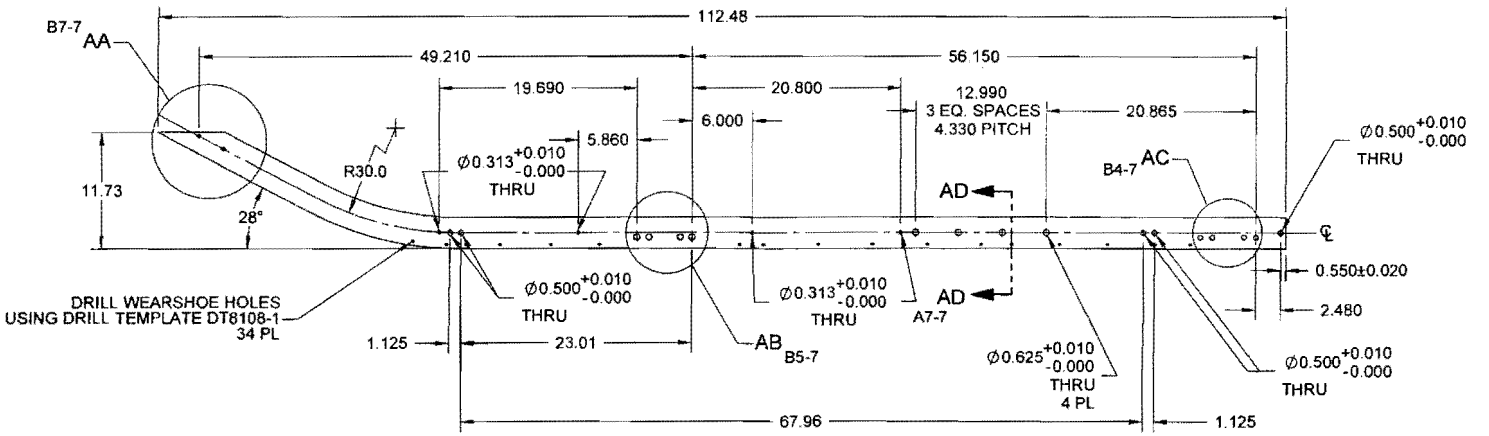
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

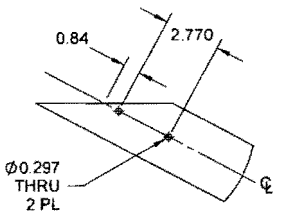
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-4 RH SKIDTUBE



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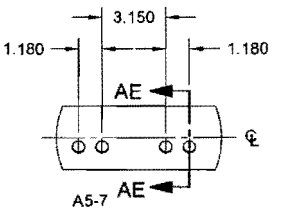

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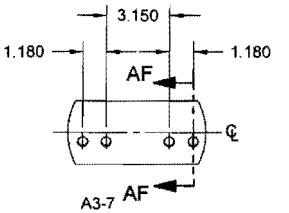

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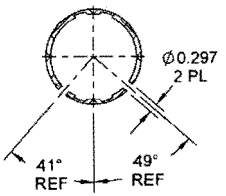
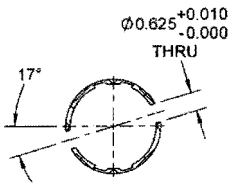
w/ 66257



SECTION AD-AD D3-7
SCALE 3X, 17 PL



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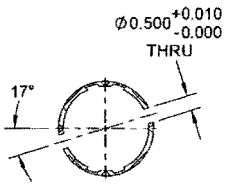
SCALE 3X, 4 PL



SECTION AF-AF B4-7
SCALE 3X, 4 PL

RELEASED 08-09-22

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 7 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE 08.07.16		

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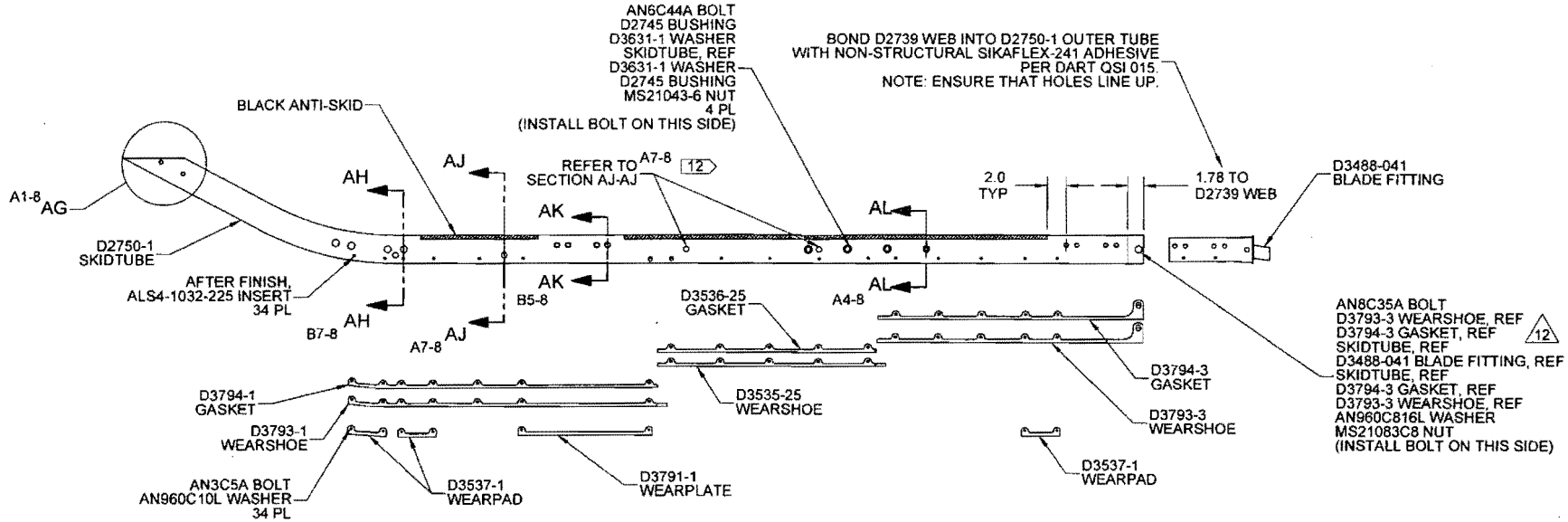
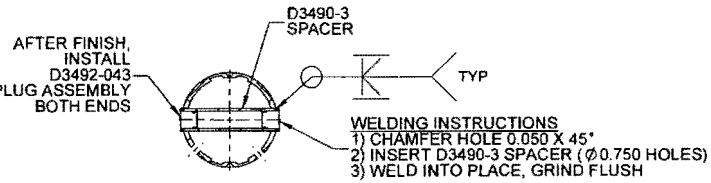
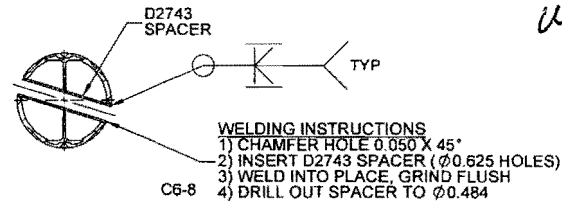


D2750-041 350 SKIDTUBE ASSEMBLY, LH

w/o 64757



SECTION AH-AH
SCALE 3X, 4 PL



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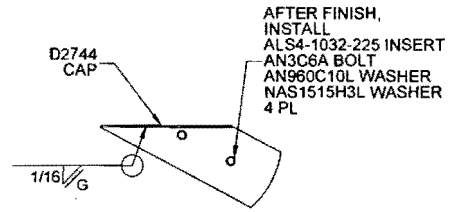
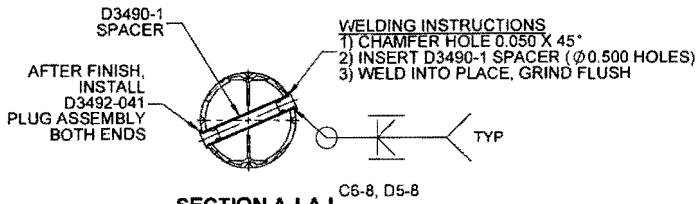
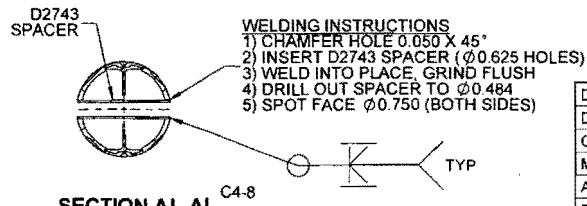


DETAIL AG
SCALE 2X
D8-8

RELEASED
05.09.22



SECTION AJ-AJ
SCALE 3X, 4 PL



SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 8 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	08.07.16	

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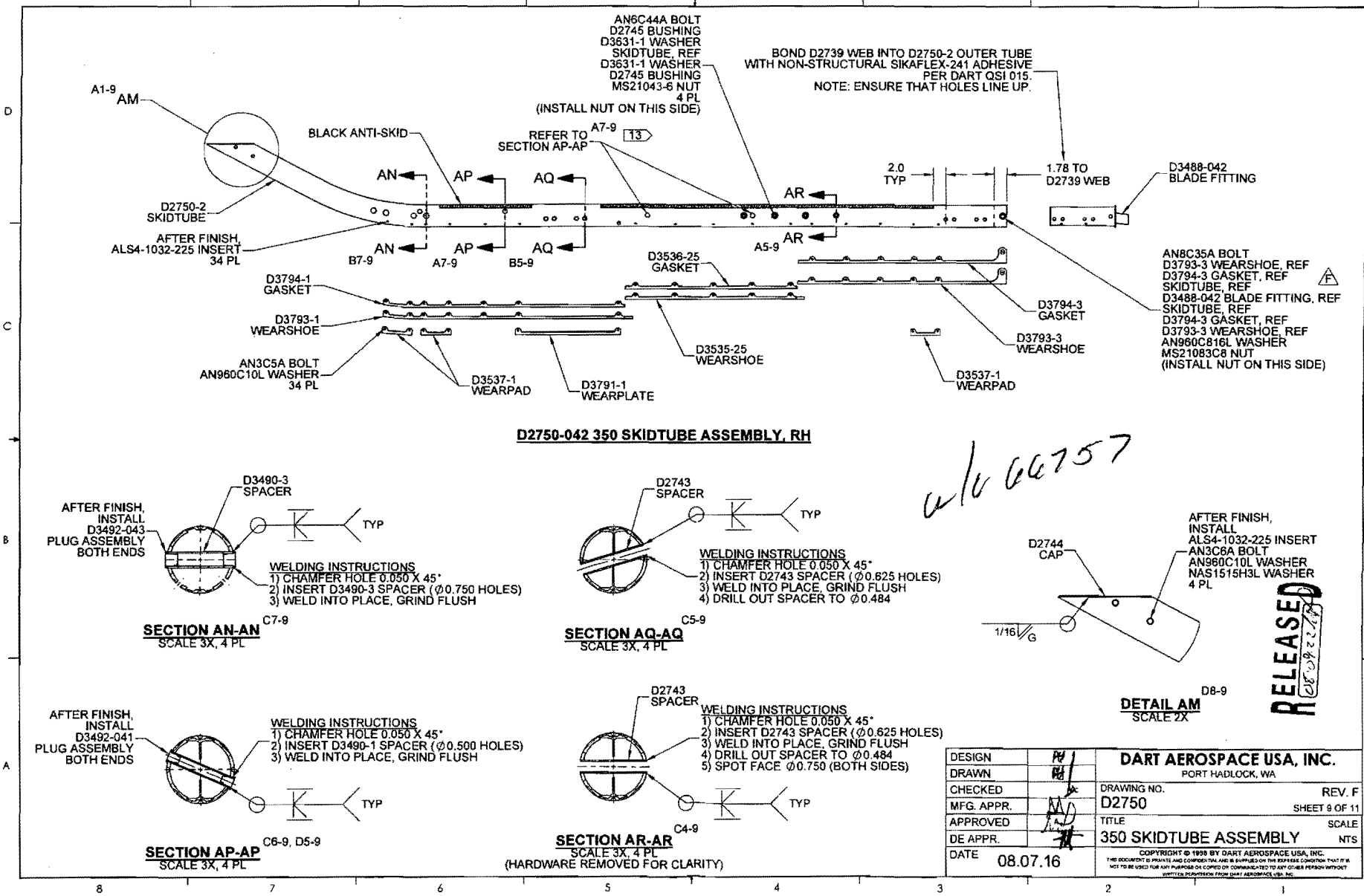
AN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL NUT ON THIS SIDE)
BOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.
A1-9
AM
BLACK ANTI-SKID
REFER TO
SECTION AP-AP
A7-9
13
2.0
TYP
1.78 TO
D2739 WEB
D3488-042
BLADE FITTING
AN
AP
AQ
AR
D2750-2
SKIDTUBE
AFTER FINISH,
ALS4-1032-225 INSERT
34 PL
B7-9
A7-9
B5-9
A5-9
D3536-25
GASKET
AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)
F
D3794-1
GASKET
D3793-1
WEARSHOE
D3794-3
GASKET
D3793-3
WEARSHOE
D3535-25
WEARSHOE
AN3C5A BOLT
AN960C10L WASHER
34 PL
D3537-1
WEARPAD
D3791-1
WEARPLATE
D3537-1
WEARPAD
D2750-042 350 SKIDTUBE ASSEMBLY, RH
w/o 66757
D3490-3
SPACER
AFTER FINISH,
INSTALL
D3492-043
PLUG ASSEMBLY
BOTH ENDS
TYP
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-3 SPACER (Ø0.750 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
C7-9
SECTION AN-AN
SCALE 3X, 4 PL
D2743
SPACER
TYP
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
C5-9
SECTION AQ-AQ
SCALE 3X, 4 PL
D2744
CAP
AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL
1/16 G
D8-9
DETAIL AM
SCALE 2X
RELEASED
AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
TYP
C6-9, D5-9
SECTION AP-AP
SCALE 3X, 4 PL
D2743
SPACER
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)
TYP
C4-9
SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)
DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 08.07.16
DART AEROSPACE USA, INC.
PORT HADLOCK, WA
DRAWING NO. D2750
REV. F
SHEET 9 OF 11
TITLE 350 SKIDTUBE ASSEMBLY
SCALE NTS
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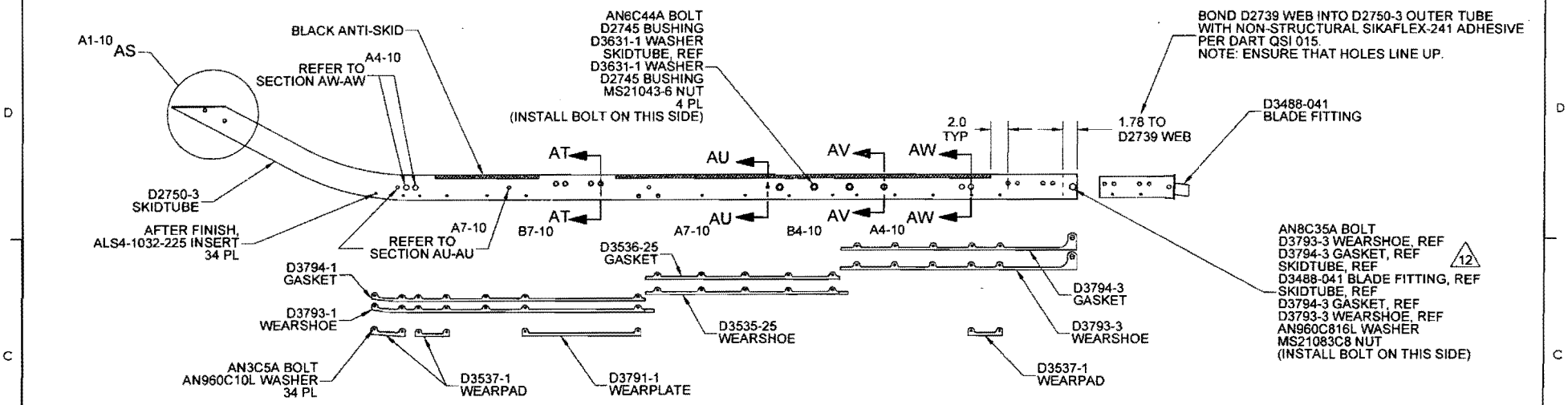
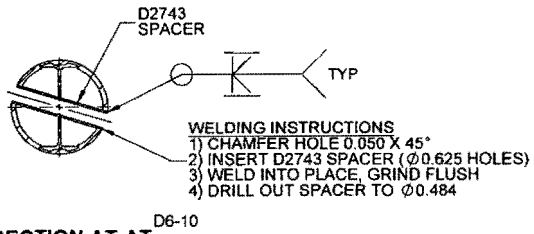
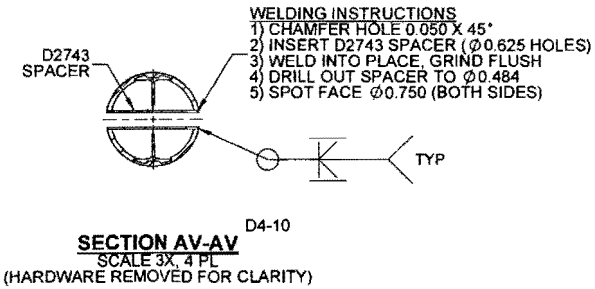


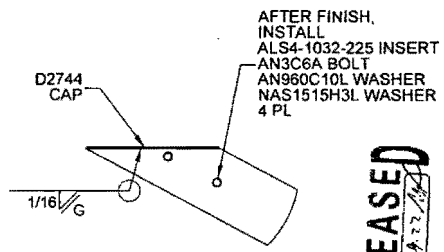
D2750-043 350 SKIDTUBE ASSEMBLY, LH



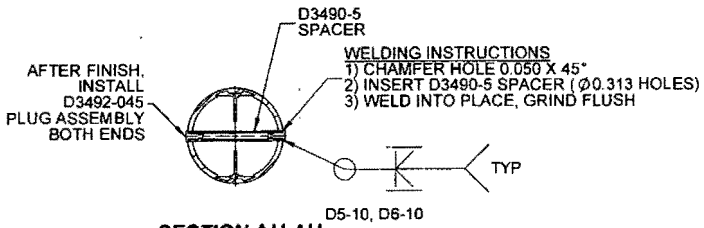
SECTION AT-AT
SCALE 3X, 4 PL



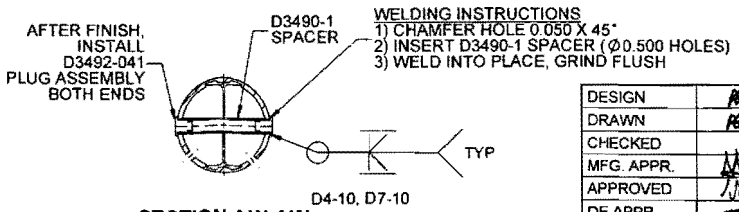
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AS
SCALE 2X



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL

RELEASED

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 10 OF 11
MFG. APPR.		
APPROVED		TITLE: 350 SKIDTUBE ASSEMBLY — SCALE: NTS
DE APPR.		
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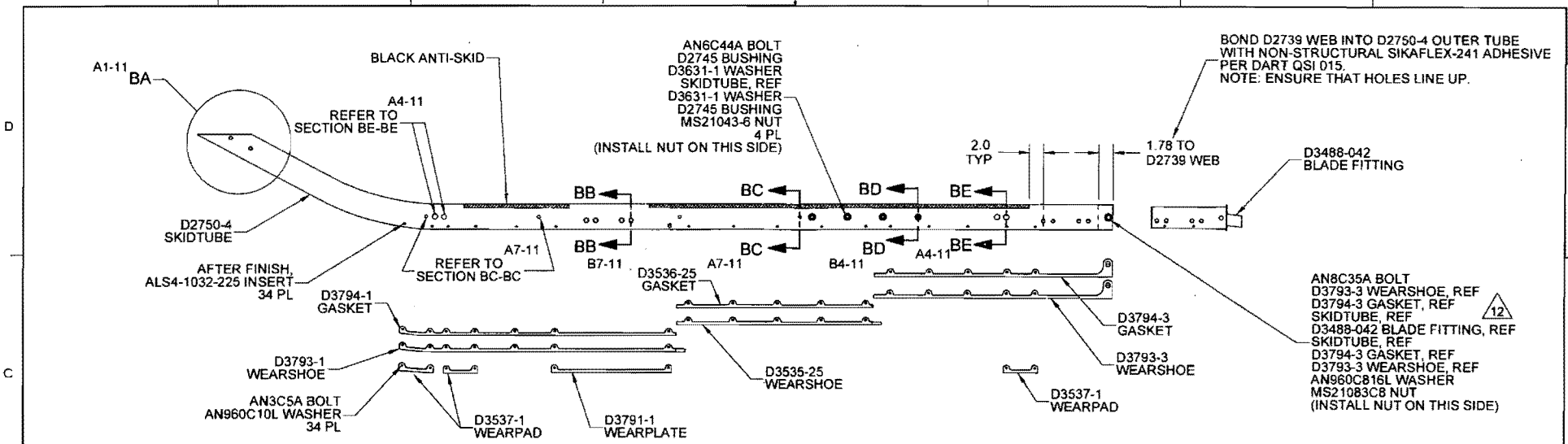
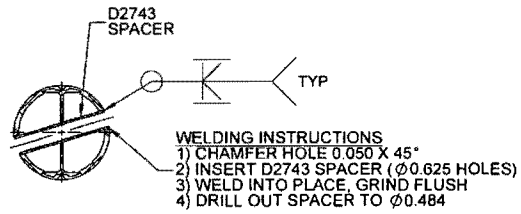
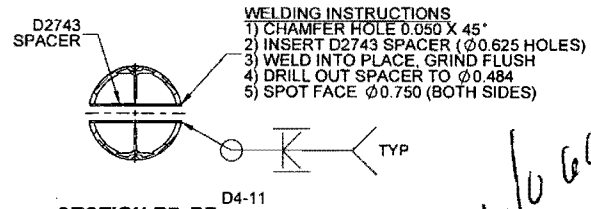


D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED 08 07 22

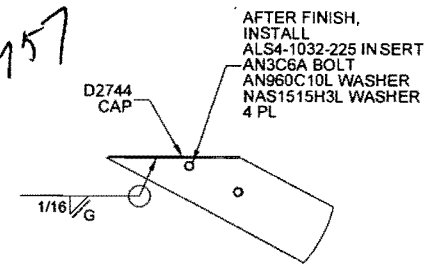


SECTION BB-BB
SCALE 3X, 4 PL

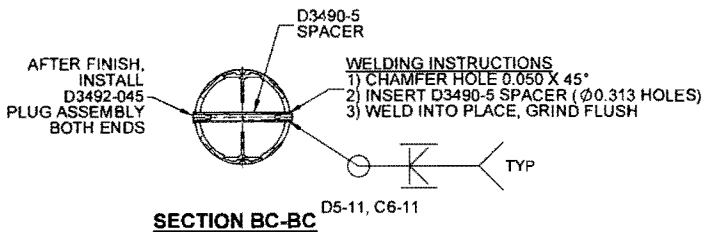


SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

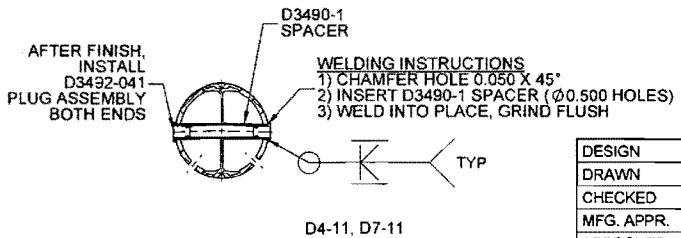
a/c 66757



DETAIL BA
SCALE 2X



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

DESIGN		**DART AEROSPACE USA, INC.** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 — REV. F — SHEET 11 OF 11
MFG. APPR.		
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NO. 243

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barkley Elliott
Job number: ~~64950~~ 64953
Part number: D 350-636-016
Description: 350 skid tube
Welding Process: Tig[✓] Mig[ ].
Base materiel: Aluminum
Current: AC[ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓]	fail[ ]
Penetration:	pass[✓]	fail[ ]

UNACCEPTABLE

Cracks:	pass[✓]	fail[ ]
Undercut:	pass[✓]	fail[ ]
Pin holes:	pass[✓]	fail[ ]
Overlap (cold lap)	pass[✓]	fail[ ]
Porosity (surface):	pass[✓]	fail[ ]
Coloration:	pass[✓]	fail[ ]

Qualifier [signature] **Date of Test Coupon** 11·01·18

Welder Barkley Elliott **Date of Test Coupon** 11-01-18

The above named individual is qualified in accordance with AWS D17.1.2001 to weld